

**\*80409\***

Page 1

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 21/02/2012    **Start Qty:** 12.00    **\*12\***

**Cust Item ID:**

**Required Date:** 06/03/2012    **Req'd Qty:** 12.00    **\*12\***

**Customer:**

**Reference:**

Approvals: Process Plan: M.L.U

**Date:** 12/02/21 **Tooling:**

Date:

Run Start \*NR1\*

**QC:**

**Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_

Date:

Stop \*NR2\*

<b>Draw Nbr</b>	<b>Revision Nbr</b>
D3642	Rev B

## FLOW WATER JET

0.00

**\*100\***

## Waterjet

## Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3642 Dwg Rev: B Prog Rev: B 2-  
Deburr if necessary

7074.050

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

## Memo

0.00

## Quality Control

120 

QC8- Inspect parts - second check

0.00

**\*120\***

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80409

\*80409\*

Page 2

February-21-12 9:06:42 AM

Item ID: D3642-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Doubler

Start Date: 21/02/2012 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

\*130\*

HandFinish

Memo

0.00

Hand Finishing

*(Signature) 12d - 28-2-12*

140

QC3- Inspect Part Finish

0.00

\*140\*

QC

Memo

0.00

Quality Control

*12d 12/02/12*

150

Identify as per dwg & Stock Location: *ST 244* 0.00

\*150\*

Packaging

Memo

0.00

Packaging

*(Signature) 12d 12-02-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 80409****\*80409\***

Page 3

February-21-12 9:06:42 AM

Item ID: D3642-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Doubler

Start Date: 21/02/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

MLJ 12/02/29

12-02-29  
(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

February-21-12 9:06:46 AM

Page 1

Work Order ID: 80409

\*80409\*

Parent Item: D3642-1

\*D3642-1\*

Parent Item Name: Doubler

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	68.6000	0.1664	2.101895			

\*M2024T3S 050\*

2024-T3 .050 sheet

\*\*

W 12 02 27

Location

MAT022

117684

Loc Qty

68.6

68.6

Loc Code

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	80409
<b>Description:</b> Doubler		<b>Part Number:</b>	D3642-1
<b>Inspection Dwg:</b> D3642	<b>Rev:</b> B	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.125	+0.004/-0.001	0.127	✓		Vern	HB-02
Ø0.098	+0.004/-0.001	0.098	✓		Vern	
0.35	+/-0.030	0.352	✓		Vern	
1.25	+/-0.030	1.257	✓		Vern	
1.700	+/-0.010	1.703	✓		Vern	
2.15	+/-0.030	2.153	✓		Vern	
3.05	+/-0.030	3.054	✓		Vern	
3.95	+/-0.030	3.955	✓		Vern	
4.078	+/-0.010	4.081	✓		Vern	
4.85	+/-0.030	4.85	✓		Vern	
5.20	+/-0.030	5.209	✓		Vern	
0.343	+/-0.010	0.348	✓		Vern	
0.40	+/-0.030	0.399	✓		Vern	
1.30	+/-0.030	1.301	✓		Vern	
3.35	+/-0.030	3.355	✓		Vern	
3.47	+/-0.030	3.473	✓		Vern	
3.79	+/-0.030	3.79	✓		Vern	
3.959	+/-0.010	3.966	✓		Vern	
4.08	+/-0.030	4.089	✓		Vern	
4.60	+/-0.030	4.609	✓		Vern	
1.537	+/-0.010	1.539	✓		Vern	
3.28	+/-0.030	3.28	✓		Vern	
3.80	+/-0.030	3.80	✓		Vern	
3.915	+/-0.010	3.915	✓		Vern	
0.450	+/-0.010	0.453	✓		Vern	
4.066	+/-0.010	4.074	✓		Vern	
4.20	+/-0.030	4.20	✓		Vern	

<b>Measured by:</b>	M/W	<b>Audited by:</b>	8	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	12.02.27	<b>Date:</b>	12/02/27	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	
B	08.12.01	Dimensions updated per Dwg Rev. B	KJ/EC	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

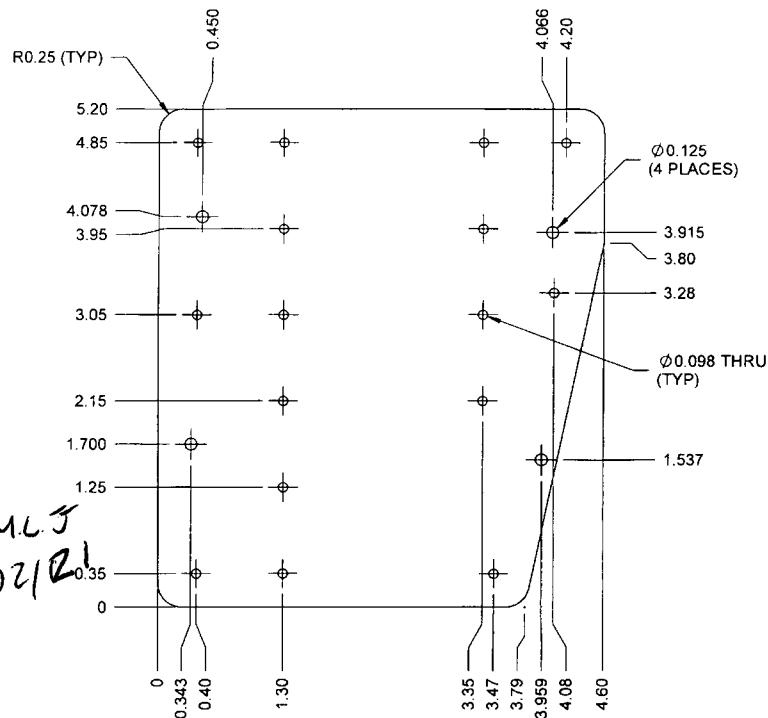
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

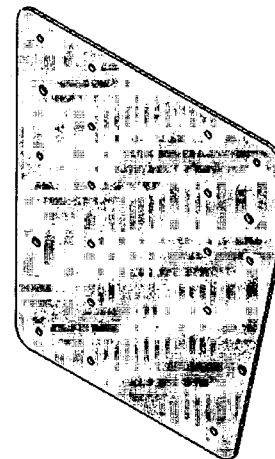
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**NOTE:** Date & initial all entries

NO 80409 MCT  
12/02/21



D3642-1 DOUBLER (WAS GENEVA P/N G10607-1/-2)



RELEASED  
07.10.16

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3642-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs

B	REMOVE -2; UPDATE -1 TO INCLUDE G10607-2	LE	07.10.16
A	NEW ISSUE; REPLACES G10607	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	UK		
CHECKED	AK		
MFG. APPR	EG		
APPROVED	TH		
DE APPR.			
DATE	07.10.16		

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D3642	REV. B SHEET 1 OF 1
TITLE DOUBLER	SCALE 4:5
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries